

Work Order ID 61408

August 24, 2010 9:01:27 AM

Page 1

Item ID: D3674-041

Revision ID:

Item Name: BRACKET ASSEMBLY

Start Date: 8/24/10

Start Qty: 12.00

Required Date: 9/07/10

Req'd Qty: 12.00

Accept

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 10/18/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3674

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 2.000") 5.400" long

ent 10/09/14

16

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-1
2-Deburr 3-Scribe batch number

SK 10/09/20 (E)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SK 10/09/20

16

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61408

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Page 2

Item ID: D3674-041

Accept



Setup Start



Revision ID:

Stop



Item Name: BRACKET ASSEMBLY

Start Date: 8/24/10 Start Qty: 12.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DTP 10/09/20

16

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3674-041 as per Dwg D3674

EP 10/09/21 16

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. 10/09/21

416

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61408

Page 3

August 24, 2010 9:01:27 AM

Item ID: D3674-041

Accept



Setup Start



Revision ID:

Stop



Item Name: BRACKET ASSEMBLY

Start Date: 8/24/10 Start Qty: 12.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location 236A

0.00



Packaging

Memo

0.00

Packaging

10/9/21 sf 160

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/21 MF
10-9-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 24, 2010 9:01:27 AM

Page 1

Work Order ID: 61408

Parent Item: D3674-041

Parent Item Name: BRACKET ASSEMBLY

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 08-04-25 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-241 Bearing Assembly		Manufactured	No			100	Each	30.0000	1	12		8/30/09/21	
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Location	Loc Qty	Loc Code
ST235B	30	
55005	2	
59435	2	
59774	6	
60494	20	

D3121-21 Bolt		Manufactured	No			140	Each	43.0000	1	12		8/30/09/21	
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Location	Loc Qty	Loc Code
ST235	43	
57376	1	
59044	2	
60493	40	

M174B1.250X02.000 17-4 SS Bar 1.250 x 2.00		Purchased	No			140	f	3.5031	0.55	6.947368			
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Location	Loc Qty	Loc Code
MAT	3.5031	
114899	3.5031	

M115545

8.8" CR 10/09/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

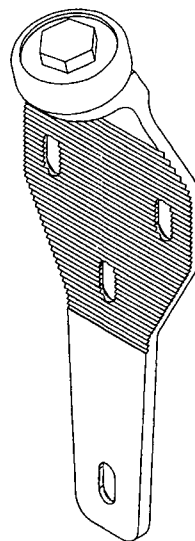
DART AEROSPACE LTD		Work Order:	61408
Description: Bracket		Part Number:	D3674-1
Inspection Dwg: D3674	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.960	+/-0.010	1.960	✓		vern JL-3	
0.750	+/-0.010	.750	✓		"	
0.605	+/-0.010	.608	✓		H-G	
3.380	+/-0.010	3.380	✓		"	
2.430	+/-0.010	2.430	✓		"	
0.380	+/-0.010	.380	✓		vern JL-3	
0.73	+/-0.030	.730	✓		"	
0.95	+/-0.030	.949	✓		"	
2.140	+/-0.010	2.135	✓		"	
2.030	+/-0.010	2.020	✓		"	
4.718	+/-0.010	4.714	✓		H-G	
4.590	+/-0.010	4.591	✓		"	
0.863	+/-0.010	.864	✓		vern JL-3	
0.130	+/-0.010	.130	✓		"	
4.600	+/-0.010	4.600	✓		"	
4.880	+/-0.010	4.880	✓		"	
5.139	+/-0.010	5.133	✓		H-G	
R0.25	+/-0.030	.25	✓		R-G	
0.080	+/-0.010	.079	✓		vern JL-3	
0.300	+/-0.010	.298	✓		"	
30°	+/-0.5°	30°	✓			
Ø0.573	+/-0.010	.573	✓		"	
0.720	+/-0.010	.724	✓		"	
0.345	+/-0.010					
Ø0.392	+0.002/-0.000	.392	✓		"	
2.173	+/-0.010	2.175	✓		"	
3.135	+/-0.010	3.135	✓			
3.963	+/-0.010	3.963	✓			
4.365	+/-0.010	4.365	✓			
0.664	+/-0.010	.664	✓		HG	
100°	+/-0.5°	100°	✓			
0.076	+/-0.010	.075	✓			
0.200	+/-0.010	.199	✓			
0.200	+/-0.010	.198	✓			
R0.10	+/-0.030	.10	✓			
0.032	+0.000/-0.010	.025	✓			

QTY -041	PART NUMBER	DESCRIPTION
X	D3674-041	ROLLER BRACKET ASSEMBLY
1	D3121-21	BOLT
1	D3121-241	BEARING ASSEMBLY
1	D3674-1	BRACKET



D3674-041 BRACKET ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO 61408
CLD/8/24

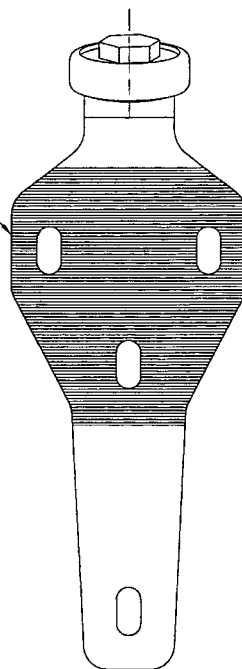
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08-06-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

A	NEW ISSUE	AJS	08.03.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>ALB</i>	DRAWING NO.	REV. A
CHECKED	<i>[Signature]</i>	D3674	SHEET 1 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	ROLLER BRACKET ASSEMBLY	NTS
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D3674-1 BRACKET



D3674-041 BRACKET ASSEMBLY

8
D3121-21 BOLT

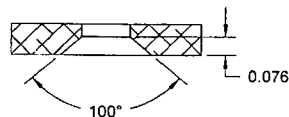


D3121-241 BEARING ASSEMBLY

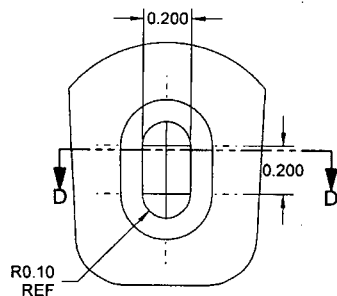
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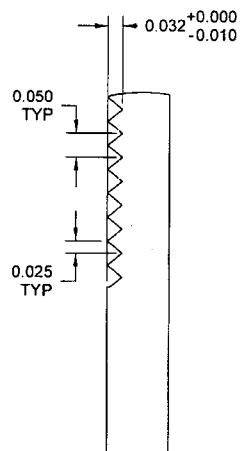
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG APPR.	<i>[Signature]</i>	D3674	SHEET 2 OF 4
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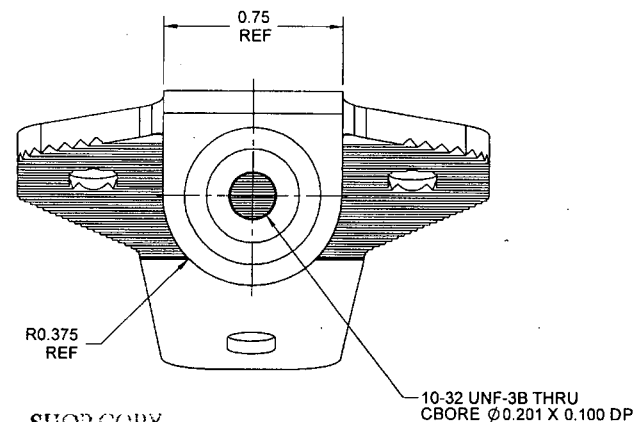
SECTION D-D



DETAIL A B2-3
SCALE 2X
(SLOT DETAIL 4PL)





DETAIL B C4-3
SCALE 4X
(RIDGE DETAIL)



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NO. 61408

VIEW C-C D3-3
SCALE 2X

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MFG. APPR.		D3674	SHEET 4 OF 4
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